

Work Order ID 52309

Tuesday, September 22, 2009 2:51:01 PM



Page 1

Item ID: D3492-043	Accept		Setup	Start	
Revision ID: C				Stop	
Item Name: Plug Assembly					
Start Date: 9/23/2009	Start Qty: 120.00		Cust Item ID:		
Required Date: 10/9/2009	Req'd Qty: 120.00		Customer:		
Reference:	<i>9/29.09.23</i>				
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start
	QC:	Date:	SPC (Y/N):	Date:	Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3492	Rev C								

100		0.00							
	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-Turn as per Folio FA632 & Dwg D3492 <input type="checkbox"/> Dwg Rev: <u>e</u> <input type="checkbox"/> Folio								
	Rev: <u>N/A</u>								

SN 09/10/01 124 ~~Ø~~

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

SN 09/10/01 124 ~~Ø~~

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

SN 09/10/02 124 ~~Ø~~

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Item ID: D3492-043

Accept



Setup Start



Revision ID: C

Stop



Item Name: Plug Assembly

Start Date: 9/23/2009 Start Qty: 120.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 120.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

0.00
09-10-5

(124)

Memo

Hand Finishing

140



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 112260

0.00

9:25

OVEN

09-10-6

(124)

Memo

(Flat End Only) ☐ START TIME:TEMPERATURE: 320° ☐ FINISH TIME:

150



QC

QC3- Inspect Part Finish

0.00

0.00
09-10-6

(124)

Memo

Quality Control

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Item ID: D3492-043

Accept



Setup Start



Revision ID: C

Stop



Item Name: Plug Assembly

Start Date: 9/23/2009 Start Qty: 120.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 120.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: FP-B

0.00

umo 09/10/07X/24

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/07 Bl 09-10-7

Picklist Print

Page 1

Tuesday, September 22, 2009 2:51:01 PM

Work Order ID: 52309



Parent Item: D3492-043RevC



Parent Item Name: Plug Assembly

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 120.00

Required Qty: 120.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	121.3753	7.8947			
6061-T6 Round Bar .750"												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

121.3753

110791

2.97

112041

8.4053

112442

50

→ 112663

60

ESP

Q32

8PT

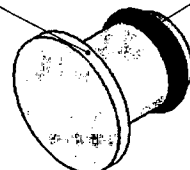
SH 09/10/09

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52309

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ △ △







NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

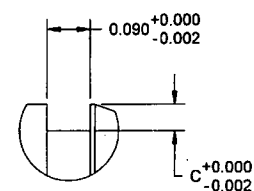
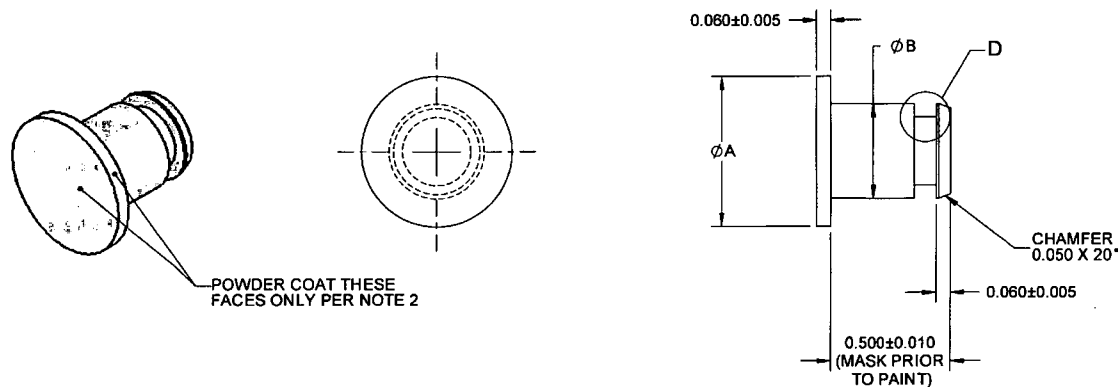
~~UNDER REVIEW~~
01-01-08
OK-ASS 08.11.12

DEO ATTACHED

RELEASED
01-01-16

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN		<div>DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA</div> <div>DRAWING NO. D3492</div> <div>TITLE PLUG</div> <div>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</div>	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		REV. C SHEET 1 OF 2	
DATE	07.10.05	SCALE 2:1	

32309



DETAIL D

D3492-XX PLUG**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

UNDER REVIEW

01.04.11

DESIGN BY D3492-XX

REV. 02 (HAWKESBURY)







15508.11.12

OK

DEO ATTACHED

RELEASED

07.11.16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3492	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	4:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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52309

DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED		MFG. APPR. <i>B</i>	APPROVED <i>MD</i>	DE APPR. <i>MD</i>		
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05	DATE 08/11/05		

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

WAS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

RELEASED
08/11/10 *MD*